

# Work Order ID 85642

Tuesday, June 12, 2012 2:38:45 PM

**\*85642\***

Page 1

Item ID: D4032-041

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Short Basket Assembly (350)

Stop

**\*NS2\***

Start Date: 6/12/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 6/26/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan: *mf*

Date: *12-06-12*

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4032

D

100

Pick Kit

0.00

**\*100\***

Packaging

Memo

0.00

Packaging

110

Assemble as per dwg

0.00

**\*110\***

HandFinish

Memo

0.00

Hand Finishing

\*\*\*\*Mask label plate to size of D4086 label, use scotchbrite red pad to lightly sand area for label, apply label \*\*\*\*

*1* *φ* *BL 12-6-19*

120

QC5- Inspect part completeness to step on W/O

0.00

**\*120\***

QC

Memo

0.00

Quality Control

*8/26/19*

*(4)*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

**Part No:** \_\_\_\_\_ **PAR #:** \_\_\_\_\_ **Fault Category:** \_\_\_\_\_ **NCR:** Yes No **DQA:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
**Resolution:** \_\_\_\_\_ **Disposition:** \_\_\_\_\_ **QA: N/C Closed:** \_\_\_\_\_ **Date:** \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 85642**

Tuesday, June 12, 2012 2:38:45 PM

**\*85642\***

Page 2

Item ID: D4032-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Short Basket Assembly (350)

Stop **\*NS2\***

Start Date: 6/12/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 6/26/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00

**\*130\***

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

Quality Control

PP85641

12/6/08

MCJ 12/06/26

MF  
12-06-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 85642  
Parent Item: D4032-041  
Parent Item Name: Short Basket Assembly (350)

Start Date: 6/12/2012 Required Date: 6/26/2012  
Start Qty: 1.00 Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.12.02 verified by:EC IPP Rev:B as per PA3 DD 10.03.10  
verified by:EC IPP Rev:C as per RevA DD 10.03.23 verified by:EC IPP  
Rev:D as per dwg revC DD 10.04.20 verified by:EC IPP Rev:E as per dwg revD DD  
10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4086-232 Placard, Max Load		Manufactured	No			100	Each	9.0000	1	Sp			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST093		9							
				78969		9							
D2530 Handle Weldment		Manufactured	No			100	Each	4.0000	1	IX Sp			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST506		4							
				82895		1							
				83423		3							
D2535 Spring		Manufactured	No			100	Each	67.0000	2	IX Sp 2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST504		67							
				83545		67							
D2537 Bushing		Manufactured	No			100	Each	34.0000	2	2x Sp 2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST504		34							
				82896		34							
D3917-3 Washer		Manufactured	No			100	Each	47.0000	6	2x 6x Sp 6			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FP		11							
				85028		11							
				ST070		36							
				84773		36							

12-6-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

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Page 2

Work Order ID: 85642

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 6/12/2012

Required Date: 6/26/2012

Start Qty: 1.00

Required Qty: 1.00

D3953-3 Manufactured No 100 Each 15.0000 2

Gas Spring Stud, Lid

Location Loc Qty Loc Code

ST075 15

82939 15

D3953-7 Manufactured No 100 Each 25.0000 2

Spring Spacer

Location Loc Qty Loc Code

ST075 25

82940 25

D3953-9 Manufactured No 100 Each 37.0000 2

Gas Spring Washer

Location Loc Qty Loc Code

ST075 37

82941 37

D3953-17 Manufactured No 100 Each 19.0000 2

Gas Spring Spacer

Location Loc Qty Loc Code

ST075 19

82937 19

D3953-19 Manufactured No 100 Each 36.0000 1

Gas Spring Bracket

Location Loc Qty Loc Code

ST075 36

82938 36

D3953-21 Manufactured No 100 Each 1.0000 1

Gas Spring Bracket

Location Loc Qty Loc Code

ST075 1

81456 1

SP

2x

SP

2x

SP

2x

SP

2x

SP

1x

885718 SP

D6-19

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Page 2

W/O:		WORK ORDER CHANGES					
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Page 3

Work Order ID: 85642

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 6/12/2012

Required Date: 6/26/2012

Start Qty: 1.00

Required Qty: 1.00

D3969-3 Manufactured No 100 Each 44.0000

Spring (Basket Lid)

1  1

Location	Loc Qty	Loc Code
ST272	44	
64285	1	
81887	3	
87942	40	

D4017-041 Manufactured No 100 Each 0.0000

Short Basket Base Assembly (350 )

1 1

12-6-19

D4018-041 Manufactured No 100 Each 0.0000

Short Basket Lid Assembly (350 )

1 1

12-6-19

AN3-14A Purchased No 100 Each 73.0000

Bolt

4  4

Location	Loc Qty	Loc Code
ST352	73	
121444	23	
121708	50	

AN3-16A Purchased No 100 Each 113.0000

Bolt

2  2

Location	Loc Qty	Loc Code
ST352	113	
117441	47	
118628	1	
120986	15	
121708	50	

AN4-12 Purchased No 100 Each 47.0000

Bolt

3  3

Location	Loc Qty	Loc Code
ST357	47	
118626	1	
121652	46	

3x

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W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 85642

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 6/12/2012

Required Date: 6/26/2012

Start Qty: 1.00

Required Qty: 1.00

AN5-17A Purchased No 100 Each 68.0000

Bolt

4

4

Location	Loc Qty	Loc Code
338	4	
121181	4	
ST338	64	
117872	34	
121541	30	

AN310-4 Purchased No 100 Each 126.0000

NUT

3

3

Location	Loc Qty	Loc Code
ST344	126	
120124	1	
121011	1	
121349	24	
121827	100	

AN310C4 Purchased No 100 Each 32.0000

Nut

2

2

Location	Loc Qty	Loc Code
ST344	32	
120360	7	
121166	3	
121444	22	

MS21042L3 Purchased No 100 Each 1,952.0000

Nut

6

6

Location	Loc Qty	Loc Code
ST300	1952	
115835	4	
117885	32	
119017	884	
119075	138	
121349	111	
121444	783	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 5

Work Order ID: 85642

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 6/12/2012

Required Date: 6/26/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L5

Purchased

No

100

Each

1,381.0000

4

Nut

Location

Loc Qty

Loc Code

300

500

121652

500

ST300

881

108827

4

116105

5

116548

43

117611

18

119109

795

17651

8

2937

8

MS24665-151

Purchased

No

100

Each

194.0000

3

Cotter Pin

Location

Loc Qty

Loc Code

ST309

194

17566

194

MS24665-300

Purchased

No

100

Each

149.0000

2

Cotter Pin

Location

Loc Qty

Loc Code

GA

145

118234

145

ST309

4

116823

4

NAS1149F0432P

Purchased

No

100

Each

642.0000

6

Washer

Location

Loc Qty

Loc Code

ST275

642

121350

642

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Tuesday, June 12, 2012 2:38:45 PM

Page 6

Work Order ID: 85642

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 6/12/2012

Required Date: 6/26/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0432R

Purchased

No

100

Each

3,826.0000

2

Washer

Location

Loc Qty

Loc Code

ST297

1070

117291

70

119124

1000

ST298

2756

121255

2756

NAS1149F0332P

Purchased

No

100

Each

596.0000

8

WASHER

Location

Loc Qty

Loc Code

ST275

596

117735

13

119225

10

120986

200

121259

200

121584

9

121825

161

17317

3

NAS1149F0563P

Purchased

No

100

Each

968.0000

4

Washer

Location

Loc Qty

Loc Code

ST275

968

121350

968

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

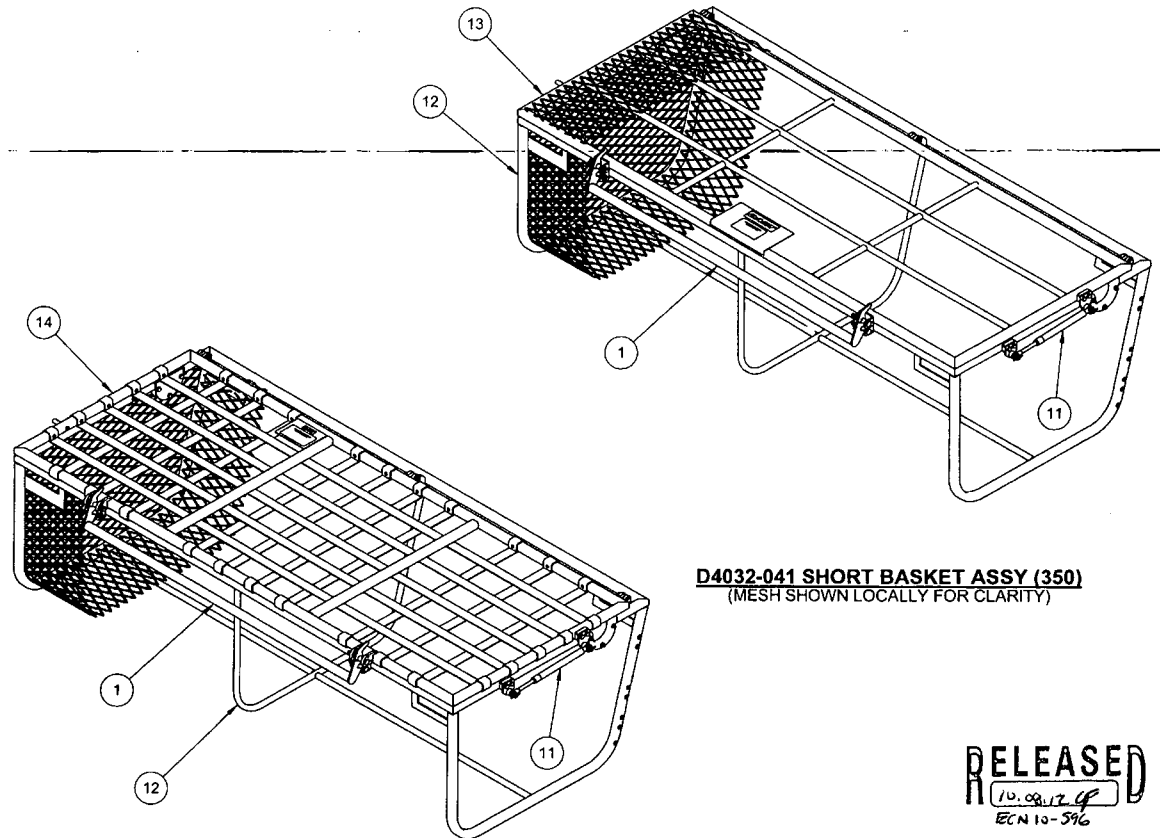
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**NOTE:** Date & initial all entries



ITEM	-041 QTY.	-043 QTY.	P/N	DESCRIPTION
	X		D4032-041	SHORT BASKET ASSY (350)
		X	D4032-043	SHORT BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	2	2	D2537	BUSHING
4	6	6	D3917-3	WASHER
5	2	2	D3953-3	GAS SPRING STUD, LID
6	2	2	D3953-7	GAS SPRING SPACER
7	2	2	D3953-9	GAS SPRING WASHER
8	2	2	D3953-17	GAS SPRING SPACER
9	1	1	D3953-19	GAS SPRING BRACKET
10	1	1	D3953-21	GAS SPRING BRACKET
11	1	1	D3969-3	SPRING
12	1	1	D4017-041	SHORT BASKET BASE ASSY (350)
13	1		D4018-041	SHORT BASKET LID ASSY (350)
14		1	D4019-041	LIGHT LID SHORT BASKET ASSY
15	4	4	AN3-14A	BOLT
16	2		AN3-16A	BOLT
17		2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20		2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	2	2	NAS1149C0432R	WASHER
29	8	8	NAS1149F0332P	WASHER
30	4	4	NAS1149F0563P	WASHER



**D4032-041 SHORT BASKET ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**D4032-043 SHORT BASKET ASSY, LIGHT LID (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**RELEASED**  
10.09.17  
ECN 10-596

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -041: 56 lbs APPROX  
-043: 45 lbs APPROX

D	QTY FOR ITEMS #28, #29 & #30 UNDER -043 WERE MISSING (B8-1); QTY FOR ITEM #3 WAS 4 (D6-1), ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3).	MB	10.07.23
C	AN5-21A BOLT WAS AN5-19A BOLT: BOM & (D3-3)	JPH	10.04.06
B	ITEM 15 D4086-232 & 16 D4086-243 REMOVED; ITEM RENUMBERED AS REQD. PLACARDS REMOVED (C6-2); TOP VIEW DETAIL REMOVED (C2-2)	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.08
REV.	DESCRIPTION	BY	DATE
DESIGN	7.95		
DRAWN	7.9		
CHECKED	7.9		
MFG. APPR.	7.95		
APPROVED	7.95		
DE APPR.	7.95		
DATE	10.07.23		
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D4032</b> <b>SHORT BASKET ASSY (350)</b> COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			
		REV. D	SHEET 1 OF 3
		SCALE	— NTS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

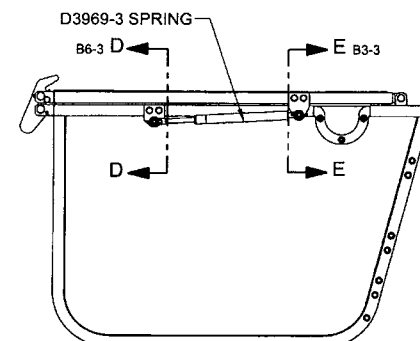
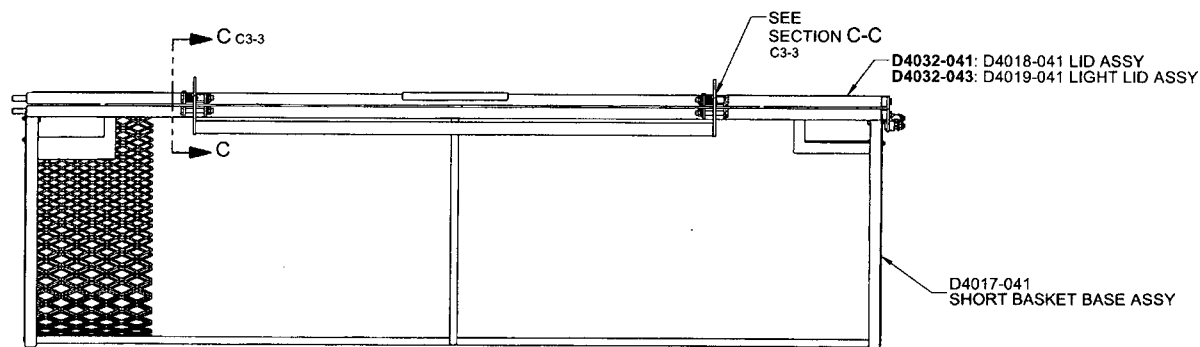
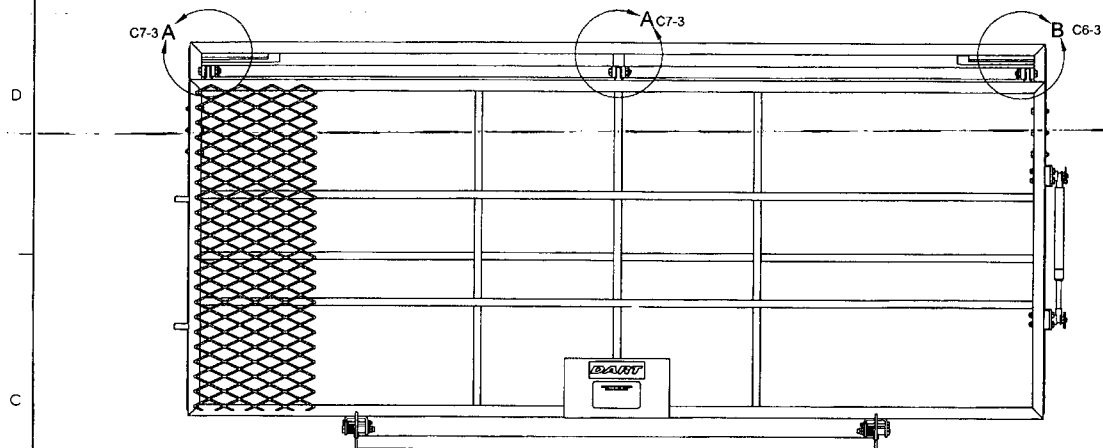
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1



**D4032-041 SHORT BASKET ASSY (350) (SHOWN)**  
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

**D4032-043 SHORT BASKET ASSY, LIGHT LID (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**RELEASED**  
10.08.12

DESIGN	ALS	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D4032</b>	REV. D
MFG. APPR.	J.F.S.	SHEET 2 OF 3	
APPROVED		TITLE	SCALE
DE APPR.		<b>SHORT BASKET ASSY (350)</b>	NTS
DATE	10.07.23	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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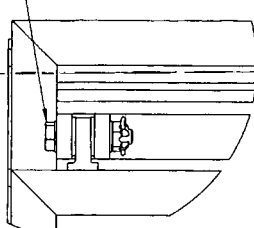
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**NOTE:** Date & initial all entries

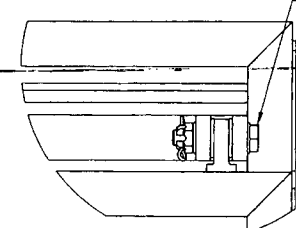
8 7 6 5 4 3 2 1

AN4-12 BOLT  
D3917-3 WASHER, 2X  
NAS1149F0432P WASHER, 2X  
AN310-4 NUT, CASTELLATED  
MS24665-151 COTTER PIN



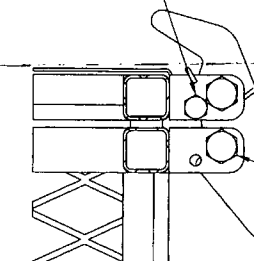
**DETAIL A** D8-2  
D6-2

AN4-12 BOLT  
D3917-3 WASHER, 2X  
NAS1149F0432P WASHER, 2X  
AN310-4 NUT, CASTELLATED  
MS24665-151 COTTER PIN



**DETAIL B** D4-2

D4032-041: AN3-16A BOLT  
MS21042L3 NUT  
D4032-043: AN3-20A BOLT  
MS21042L3 NUT

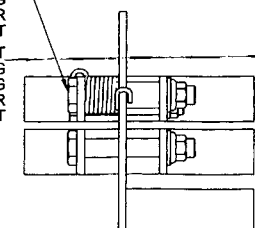


**SECTION C-C** B5-2  
B7-2

D4032-041: AN5-17A BOLT  
D2537 BUSHING  
D2535 SPRING  
NAS1149F0563P WASHER  
MS21042L5 NUT

D4032-043: AN5-21A BOLT  
D2537 BUSHING  
D2535 SPRING  
NAS1149F0563P WASHER  
MS21042L5 NUT

AN5-17A BOLT  
NAS1149F0563P WASHER  
MS21042L5 NUT



**VIEW F-F** C3-3

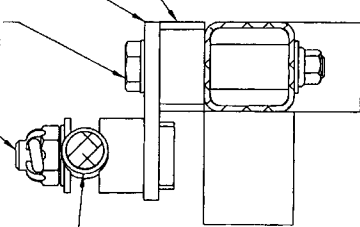
D2530 WELDMENT  
REF

D3953-17 GAS SPRING SPACER  
D3953-21 GAS SPRING BRACKET

AN3-14A BOLT  
NAS1149F0332P WASHER, 2X  
MS21042L3 NUT  
2 PL

D3953-3 GAS SPRING STUD, LID  
D3953-7 GAS SPRING SPACER  
D3953-9 GAS SPRING SPACER  
NAS1149C0432R WASHER  
AN310C4 NUT, CASTELLATED  
MS24665-300 COTTER PIN

D3969-3 SPRING  
REF



**SECTION D-D** B2-2

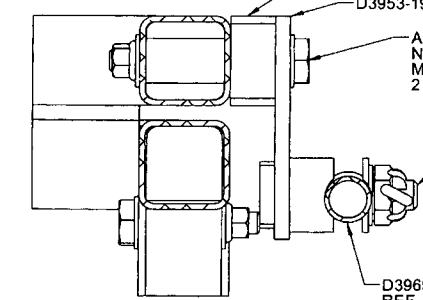
D3953-17 GAS SPRING SPACER

D3953-19 GAS SPRING BRACKET

AN3-14A BOLT  
NAS1149F0332P WASHER, 2X  
MS21042L3 NUT  
2 PL

D3953-3 GAS SPRING STUD, LID  
D3953-7 GAS SPRING SPACER  
D3953-9 GAS SPRING SPACER  
NAS1149C0432R WASHER  
AN310C4 NUT, CASTELLATED  
MS24665-300 COTTER PIN

D3969-3 SPRING  
REF



**SECTION E-E** B1-2

**RELEASED**  
10.08.17.0

DESIGN	AKS	<b>DART AEROSPACE LTD</b>	
DRAWN	AKS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AKS	DRAWING NO.	REV. D
MFG. APPR.	JFS	D4032	SHEET 3 OF 3
APPROVED	JFS	TITLE	SCALE
DE APPR.	JFS	SHORT BASKET ASSY (350)	NTS
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries